

Date: Wednesday, 25/06/2008 11:59:50 AM
User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SPACER BUSHING	
Job Number	: 40084		Part Number	: D23271	
Estimate Number	: 10823		Drawing Number	: D2327 REV D	
P.O. Number	:		Project Number	: N/A	
This Issue	: 25/06/2008 S.O. No. :		Drawing Revision	: D	
Prsht Rev.	: NC		Material	:	
First Issue	: / / Type : MACHINED PARTS		Due Date	: 04/07/2008 Qty:	
Previous Run	: 36920			<i>12</i> Um: Each	
Written By	:			<i>JUL 08.6.25</i>	
Checked & Approved By	:				
Comment	: Est. D 05.11.02 Removed 303 SS KJ/EC				
	Est Rev:E Removed 303SS JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304R0375	304 SS ROUND BAR
		Comment: Qty.: 0.1860 f(s)/Unit Total : 9.2978 f(s)
		Inventory
		Material: AISI 304 Round Bar Ø0.375"
	(M304R0.375)	Batch: <i>M107403</i> <i>J.F. 08/10/08 (12)</i>
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
		Comment: HARDINGE CNC LATHE SMALL
		Turn per Folio FA232 and Dwg D2327
		Deburr
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
		<i>J.F. 08/10/08 (12)</i>
4.0	QC8	SECOND CHECK
		Comment: SECOND CHECK
		<i>10 08/10/08 (12)</i>
5.0	PACKAGING 1	PACKAGING RESOURCE #1
		Comment: PACKAGING RESOURCE #1
		<i>CARL</i>
		Identify and Stock
		Location: _____
		<i>18 08/10/08 (12)</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER BUSHING

Job Number: 40084

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



08/07/08

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-07-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	40084
Description: Spacer Bushing	Part Number:	D2327-1
Inspection Dwg: D2327	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

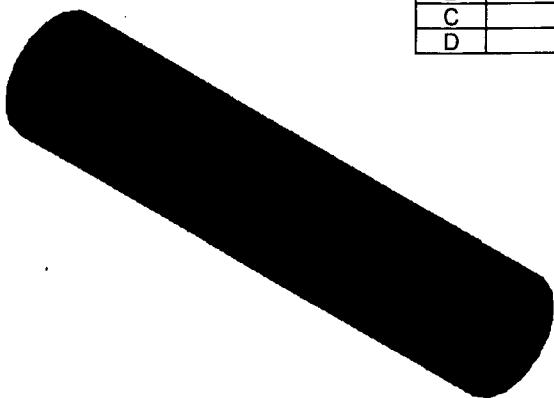
X First Article Prototype

Measured by:	J-F.	Audited by:	RJ	Prototype Approval:	N/A
Date:	08/07/03	Date:	08/07/03	Date:	N/A

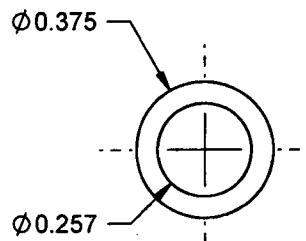
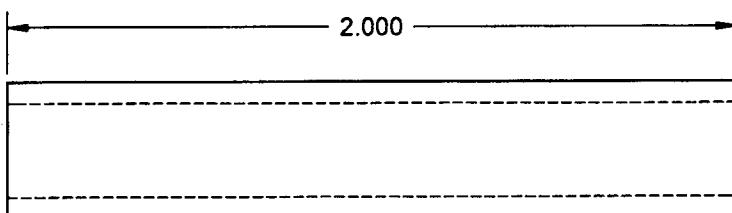
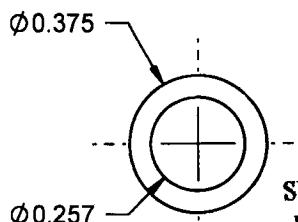
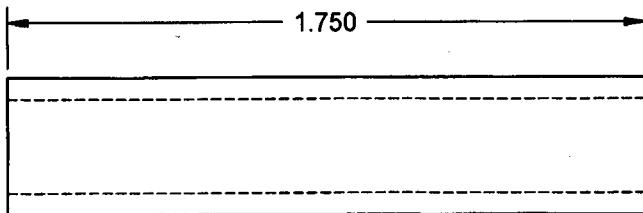
Rev	Date	Change	Revised by	Approved
A	03.11.27	New Issue	KJ/RF	
B	06.11.24	Dwg Revision revised	KJ/JLM	
C	08.02.01	Tolerance revised for Ø0.375	KJ/EC/DD	

DART

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>CH</i>	DRAWING NO. D2327	REV. D SHEET 1 OF 1
DATE 06.10.12		TITLE SPACER BUSHING	SCALE 2:1
REV	DATE	DESCRIPTION	
A	94.12.17	NEW ISSUE	
B	95.12.06	LENGTH CHANGE	
C	03.05.13	303 SS SPEC ADDED	
D	06.10.12	REMOVE 303 SS MATERIAL	



RELEASED

06.11.14 *[Signature]***D2327-1 SPACER BUSHING****D2327-3 SPACER BUSHING****NOTES:**

- 1) MATERIAL: AISI 304/316 SS, Ø0.375, 0.065 WALL SEAMLESS ROUND TUBING
(REF. DART SPEC M304TR0.375W.065)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *Y0084*
D